



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2143

Job Sheet 175743



Part No: D2143

Job Qty: 12 ea

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV C1 IPP C 00.05.18 Added inspection level 8 EC IPP Rev:D Now on WaterJet 06-10-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		4/23/18	0.00	0.00	Start Up Waterjet		<i>SE 8/24/24</i>
100	Waterjet	12 pcs		4/23/18	0.00	0.44	Waterjet1		<i>SE 8/24/24</i>
120	QC	12 pcs		4/23/18	0.00	0.00	QC8		<i>38</i>
140	Brake NC	12 pcs		4/23/18	0.02	0.48	Brake NC 2		<i>DA69 SD</i>
150	QC	12 pcs		4/23/18	0.00	0.00	QC5		<i>38</i>
160	HandFinish	12 pcs		4/23/18	0.00	0.26	HandFinish1		<i>BEB 18-6-20</i>
170	Powdercoat	12 pcs		4/24/18	0.00	0.20	Powdercoat1		<i>BL 18-6-21</i>
180	QC	12 pcs		4/24/18	0.00	0.00	QC3		<i>38</i>
190	Packaging	12 pcs		4/24/18	0.00	0.00	Packaging3-1		<i>21</i>
200	QC21-SA	12 Ea		4/24/18	0.00	0.00	QC21		<i>21</i>

Part Op 100 - 1-Cut as per Dwg D2143

Descriptions: 140 - Bend as per Dwg D2143

170 - START TIME: *3:40* OVEN TEMPERATURE: *320°* FINISH TIME: *4:10*

M138834

5007177

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.040	5052-H32 .040 Sheet	.7920 sf (.066 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M5052H32S.040	1	12	0



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Container No: S064793



Part: D2143

Job No: 175743

Serial No/Batch: S064793

Revision:

Inspector:

Date: 04/24/18

0-100
S1
0-86
38
DVP
06
32
0V63
36
0V63

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.340Inches ± 0.010	0.350 0.330	0,341	
2	Hinge Bracket	0.625Inches ± 0.010	0.635 0.615	0,628	
3	Hinge Bracket	1.000Inches ± 0.010	1.010 0.990	1,001	
4	Hinge Bracket	0.063Inches ± 0.010	0.073 0.053	0,063	Radius
5	Hinge Bracket	2.656Inches ± 0.010	2.666 2.646	2,655	
6	Hinge Bracket	3.317Inches ± 0.010	3.327 3.307	3,315	
7	Hinge Bracket	0.257Inches + 0.005 - 0.000	0.262 0.257	0,260	Diameter
8	Hinge Bracket	0.171Inches + 0.005 - 0.000	0.176 0.171	0,173	Diameter
9	Hinge Bracket	1.660Inches ± 0.010	1.670 1.650	1,660	
10	Hinge Bracket	2.844Inches ± 0.010	2.854 2.834	2,844	
11	Hinge Bracket	1.659Inches ± 0.010	1.669 1.649	1,660	
12	Hinge Bracket	0.125Inches ± 0.010	0.135 0.115	0,125	Radius
13	Hinge Bracket	2.312Inches ± 0.010	2.322 2.302	2,312	

Plex 4/10/18 1:56 PM Dart.Gagnon.Michelle